Work Order ID Wednesday, August 31,									÷	Page 1
Item ID: D3454	4-5		Accept					Setup Star	-t 	
Revision ID: Item Name: Bushin	ng						··	Sto		
Start Date: 9/1/20 Required Date: 9/15/2 Reference:	Start Qty: 20.00			Cust Item I Customer:	D:					
**************************************	ess Plan: MF	Date: []- 09-0]	Tooling:	Da	 ite:	_	R	Run Star	t	
		Date:	SPC (Y/N):		ite:			Stop		
Sequence ID/ Work Center ID	Operation Description	·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3454	Rev B		-							
100 Hardinge	Hardinge CNC LATHE S		0.00				20	Ø.		· <u></u>
Hardinge CNC Lathe Small	1-TURN AS REV: ////	PER FOLIO FA572 & DWG	G D3454,□FOLIO □2-DEBURR AS REQU	JIRED				/		
110 	QC2- Inspect parts off ma	achine FAI/FAIB	0.00				20	de la constant de la		-
Quality Control		2)	10/2/19	1						
120	QC8- Inspect parts - seco	nd check	0.00	11.7.	17		20	4		
QC Quality Control	Мето		0.00							

Dart Aerospace L

	. Johan.	7 =1.5										
W/O:			W	ORK ORDER CHANG	ES					•		
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								:				
Part No:PAR		PAR #:	Fault Cat	egory:	_ NCR:	:Yes N	o DQ	4 :	Date:			
Resolution:			Dispositi	on:	QA: I	N/C Clos	sed:		Date:			
NCR:			WORK ORE	DER NON-CONFORM	ANCE	(NCR)				Ť		
DATE	STEP	Description of NC			tion B	C: 0	Verification Appro		Approval	Approval		
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector		
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Work Order ID 73343

Wednesday, August 31, 2011 11:05:38 AM



Page 2

Item ID:

D3454-5

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Bushing

9/1/2011

Start Qty: 20.00

Reg'd Oty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Tooling: Date:

Date:

Run

Start

Stop



Required Date: 9/15/2011

Date:

SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp.

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Deburr if necessary.

Set Up/ **Run Hours**

0.00

Number

Stamp

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

150

Packaging Packaging

Identify as per dwg & Stock Location \$754.

0.00

Memo

Memo

0.00

Dart Aerospace	Ltd
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W/O: WORK ORDER CHANGE									***	12 · · · ·
DATE	STEP	PRO	OCEDURE CH	ANGE	E	У	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						1			:	
									-	
Part No	·	PAR #:	Fault Cat	egory:	NCR:	Yes N	lo DQ	A:	_ Date: _	
	R	esolution:	Dispositi	on:	QA: N	/C Clo	sed:		Date:	
NCR:			WORK OR	DER NON-CONFORM	ANCE (NCR)				V
DATE	CTED	Description of NC			ction B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date		ion C	Chief Eng	QC Inspector
		2					-			
		·								
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Work Order ID 73343

Wednesday, August 31, 2011 11:05:38 AM



Page 3

Item ID:

D3454-5

Accept

Setup Start



Revision ID:

Item Name: **Start Date:**

Required Date: 9/15/2011

Bushing

9/1/2011

QC:

Start Qty: 20.00

Req'd Qty: 20.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Tool # Plan

Code

Start

Run

Accept

Qty

Stop



Stop

Reject

Qty

Sequence ID/

Work Center ID

160

QC

Memo

QC21- Final Inspection - Work Order Release

Date:_____

0.00

0.00

Insp. Number Stamp

Reject

Quality Control

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	GES				t .
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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								-	
				279			<u> </u>		
Part No:		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date: _	
	Re	solution:	Dispositi	on:	QA: N/C C	losed:		Date: _	
NCR:	T		WORK ORD	DER NON-CONFORM	ANCE (NCI	₹)			
		Description of NC			tion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
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Picklist Print

Wednesday, August 31, 2011 11:05:34 AM

Work Order ID: 73343

Parent Item:

D3454-5

Parent Item Name: Bushing



Start Date: 9/1/2011

Required Date: 9/15/2011

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV. A 05.11.17

New Issue

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	124.7700	0.0375	0.789474			

303 Round Bar 0.750

Location	Loc Qty	Loc Code
MAT028	124.77	
117328	36.97	
117798	9.8	
118400	36.4	
118509	41.6	

Dart Aerospace	• Ltd
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W/O:			WO	RK ORDER CHANG	ES		_		٤
DATE	STEP	· PRC	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							-		
Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	1:	QA: N/C C	closed:		Date: _	
NCR:			WORK ORDI	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B Sign		ication	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Date		tion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	73343
Description: Bushing	Part Number:	D3454-5
Inspection Dwg: D3454 Rev: B		Page 1 of 1

	FIRS	STARTICLE	NOPECII	ON CHE	CKLIST	
		X First Arti	cle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.250	+0.005/-0.000	25/			<11-9	
Ø0.372	+0.000/-0.005	-307				
0.400	+0.005/-0.000	-403				
Ø0.75	+0.008/-0.001	-74 9				
0.060	+0.010/-0.000	-034				
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						()
		-				
			-			

Measured by:		Audited by:	Prototype Approval:	N/A
Date:	4/8/18	Date: 11 . 9. 19	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue	KJ/JLM	
В	07.01.17	0.60 dimension removed	KJ/JLM	1
С	07.09.06	0.060 dimension added	KJ/JLM , ,	
D	09.05.04	Tolerance for 0.060 revised	KJ/DD	Jull
	•	 	1/1	7 7

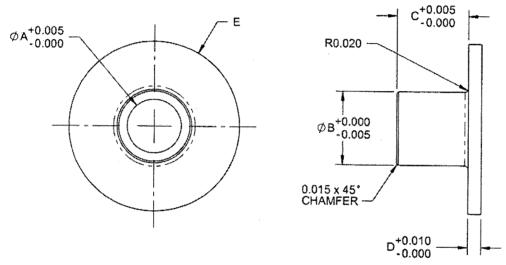
Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•			14. 2		
Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA	\;	Date: _	
			Disposition: Q						
NCR:		: 1	WORK ORDE	R NON-CONFORMAN	ICE (NCF	₹)	·		
	STEP	Description of NC		Corrective Action Section B		Verification		Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign (Section Section	Section C	Chief Eng	QC Inspector
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DESIGI R	•	DRAWN BY RF	DART AERO: HAWKESBURY, OF	
CHECK	ED	APPROVED#	DRAWING NO. D3454	REV. B
DATE	05.1	2.05	TITLE BUSHING	SCALE 2:1
Α	0:	5.09.02	NEW ISSUE	
В	0	5.12.05	REVISE -5/-7	

RELEASED 05.12.09



D3454-X

1) SPECIFICATION: D3454-X BUSHING



DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (in)	
-1	0.316	0.435	0.420	0.060	1.00	1
-3	0.316	0.435	0.400	0.060	0.75	1
-5-5-	0.250	0.372	0.400	0.060	0.75_	
-7	. 0.250	0.372	0.343	0.060	0.75	7



NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
 2) FINISH: NONE
 3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE			В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
									,				

Part No:		PAR #:	Fault Category: No			es N	o DQ	A:	Date:				
	R	esolution:	Disposition:			_ QA: N/C Closed:			Date:				
NCR:			WORK ORD	ER NON-CONFORM	ANCE (I	ICR)	-						
DATE	STEP	Description of NC	Corrective Action Section E Initial Action Description			ign &	Verification Section C		Approval	Approval			
		Section A	Chief Eng	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector			
i									1				